

Work Order ID 75254

October-19-11 1:36:25 PM

75254

Page 1

Item ID: D2965-3 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: 10.00 Stop ***NS2***
 Item Name: Cap
 Start Date: 19/10/2011 Start Qty: 10.00 ***10*** Cust Item ID:
 Required Date: 07/11/2011 Req'd Qty: 10.00 ***10*** Customer:
 Reference:

Approvals: Process Plan: M.L.J. Date: 11/10/19 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2965	Rev B								

100
100
 Lathe Conv
 Conventional Lathe
 CONVENTIONAL LATHE
 Memo
 Turn as per Dwg D2965
 USE DT9536 PLUG
 0.00
 11/10/21
 11/10/28
 10 0

110
110
 QC
 Quality Control
 QC2- Inspect parts off machine FAI/FAIB
 Memo
 0.00
 11/10/21
 11/10/28
 10 0

120
120
 QC
 Quality Control
 QC8- Inspect parts - second check
 Memo
 0.00
 11-10-30
 0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130		0.00							
130	Small Fab					(10)			
Small Fab	Memo	0.00	SB	11/10/3					
Small Fab	Drill as per Dwg D2965 with DT8538Debur and Tumble								

140	QC5- Inspect part completeness to step on W/O	0.00							
140									
QC	Memo	0.00							
Quality Control									

150	Powdercoat	0.00							
150									
Powdercoat	Memo	0.00							
Powder Coating	START TIME: _____ FINISH TIME: _____ OVEN TEMPERATURE: _____								

W118439 10:15 3200F 10:45

10X0 M-L 11/11/16

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Item ID: D2965-3

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Cap

Stop ***NS2***

Start Date: 19/10/2011 Start Qty: 10.00

10

Cust Item ID:

Required Date: 07/11/2011 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC3- Inspect Part Finish	0.00							
160									
QC	Memo	0.00							
Quality Control									
170	Small Fab	0.00							
170									
Small Fab	Memo	0.00							
Small Fab	Install Inserts as per Dwg D2965								
180	QC5- Inspect part completeness to step on W/O	0.00							
180									
QC	Memo	0.00							
Quality Control									

10 BL 11-11-16

10 BL 11-11-18

Subling

10

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	Identify as per dwg & Stock Location: <i>FP2.</i>	0.00							
190						<i>10</i>	<i>BR</i>	<i>11-11-18-</i>	
Packaging	Memo	0.00							
Packaging									
200	QC21- Final Inspection - Work Order Release	0.00							
200									<i>Mu/21</i>
QC	Memo	0.00							
Quality Control									

211-11-21
(10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Picklist Print

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Page 1

Work Order ID: 75254

75254

Parent Item: D2965-3

D2965-3

Parent Item Name: Cap

Start Date: 19/10/2011

Required Date: 07/11/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev A New Issue 06-12-19 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
ALS7-1032-225		Purchased	No			110	Each	1,173.000	2	20			
AI S7-1032-225									**			<i>BR 11-11-18.</i>	
INSERT													
				<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>				<i>20.</i>			
				ST282	1173								
				100896	146								
				111529	27								
				118520	1000								
D2965P		Purchased	No			170	Each	0.0000	1	10			
D2965P									**				
Cap													

71371

10 11/10/28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

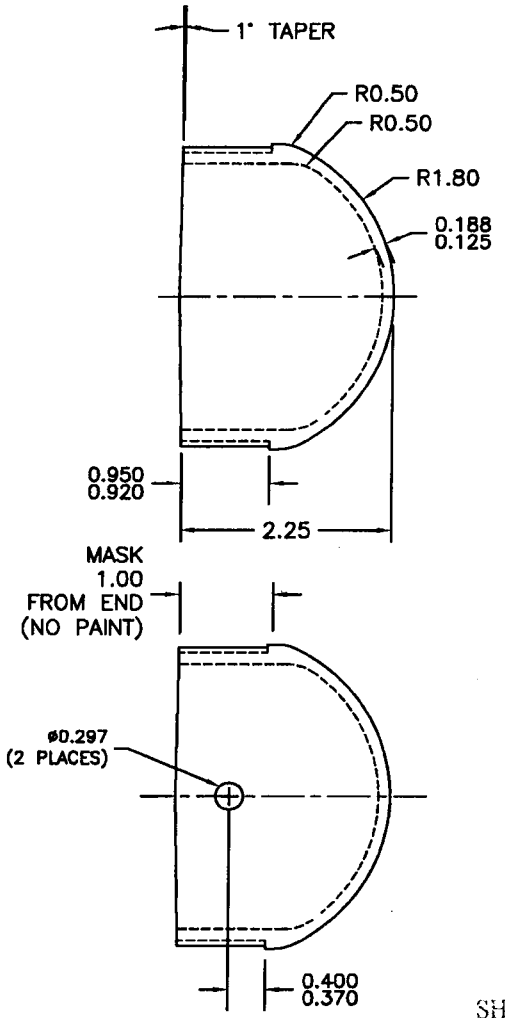
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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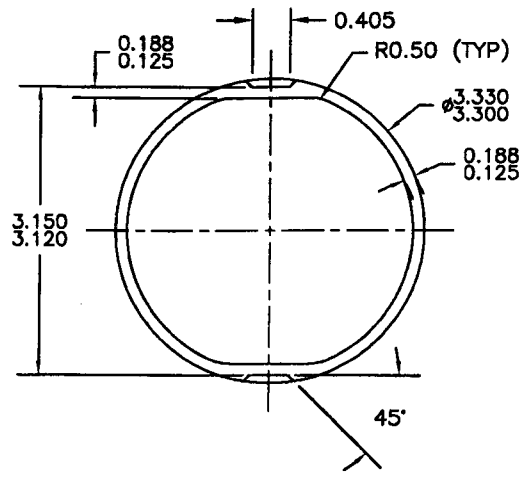


RELEASED
06.12.12

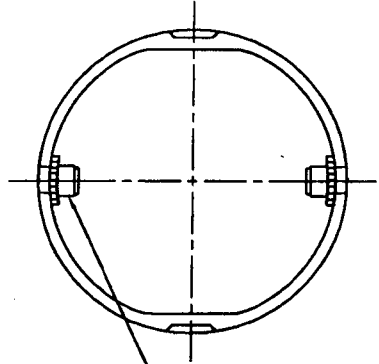
DESIGN	014	DRAWN BY	014	DART AEROSPACE USA, INC.
CHECKED		APPROVED		PORT HADLOCK, WA
DATE	06.11.01	DRAWING NO.	D2965	REV. B
		TITLE	CAP	SHEET 1 OF 2
				SCALE
A	00.02.24	NEW ISSUE		1:2
B	06.11.01	ADD -3 CAP		



D2965 CASTING DETAIL



D2965 FINISH DETAIL



INSTALL AELS-1032-225 INSERT
(2 PLACES)

D2965 CAP

- 1) MATERIAL: CAST ALUMINUM ALLOY A356.2 (F)
- 2) FINISH: POWDER COAT PER QSI 005 4.3 TO MATCH REST OF SKIDTUBE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE INCHES

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO 75254
M.C.T.
11/10/9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DART

RELEASED

06.11.01

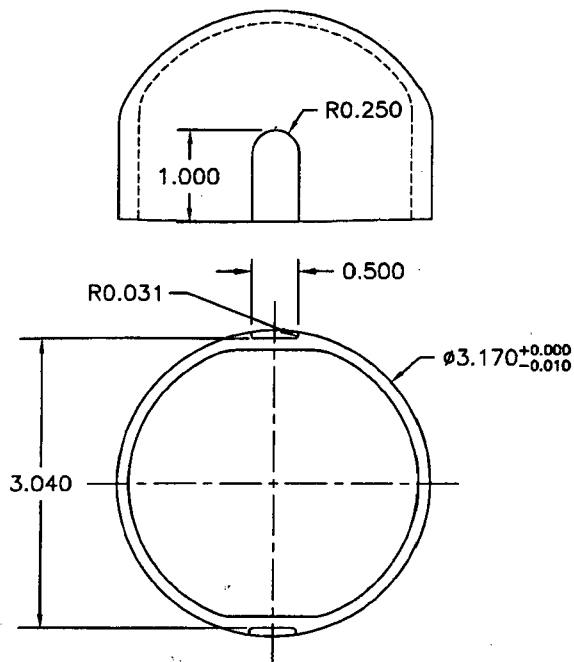
DESIGN	PH	DRAWN BY	PH	DART AEROSPACE USA, INC.	REV. B
CHECKED	PH	APPROVED	PH	PORT HADLOCK, WA	SHEET 2 OF 2
DATE	06.11.01	TITLE	D2965	SCALE	1:2
		CAP			

MASK
1.00
FROM END
(NO PAINT)

Ø0.297
INSTALL AELS-1032-130
AFTER FINISH
(2 PLACES)

0.400
0.370

D2965-3 FINISH DETAIL



D2965-3 CAP MACHINING DETAIL
(MAKE FROM D2965 CAP)

D2965-3 CAP

- 1) MATERIAL: MAKE FROM D2965 CAP
- 2) FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE INCHES

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries